

Split

Work Order ID 87938-2

July-19-12 11:30:14 AM

Item ID: D3245-043

Accept

87938

Page 1

Revision ID:

Item Name: Door Assembly

Start Date: 19/07/2012 Start Qty: 10.00

10

Required Date: 02/08/2012 Req'd Qty: 10.00

10

Reference:

Approvals: Process Plan: *807 MJC*

Date: 12/07/19 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr Revision Nbr

D3245 C

100 Pick Kit

100
Packaging
Packaging

Memo

0.00

110 Small Fab

110
Small Fab
Small Fab

Memo

0.00
1-Install Studs and Gromets as per Dwg D32453-Bond Gasket using 3M
ADHESIVE as per Dwg D3245A/R 3M 1300/1300L ADHESIVE
Batch: *104297*

120 QC5- Inspect part completeness to step on W/O

120
QC
Quality Control

Memo

0.00

9

13321

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

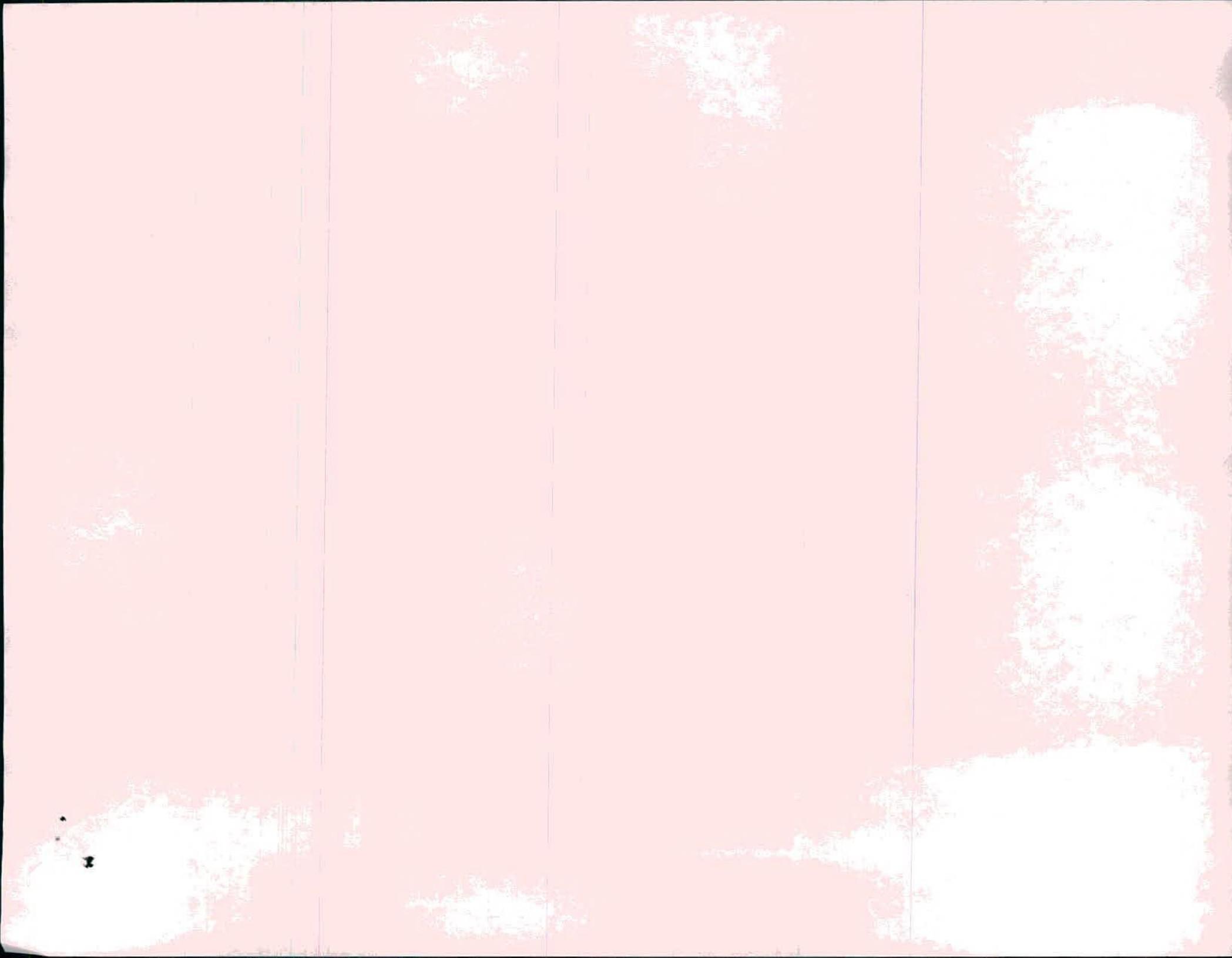
Stop *NR2*

Tool ID Tool # Plan
Code Accept Reject Reject
Qty Qty Number Insp.
Stamp

9X *8/03/2012*

9X *8/03/2012*

9 *8/03/2012*



Work Order ID 87938

July-19-12 11:30:14 AM

87938

Page 2

Item ID: D3245-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Assembly

Start Date: 19/07/2012 Start Qty: 10.00

10

Required Date: 02/08/2012 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
130

130

Packaging
Packaging

Operation
Description

Identify as per dwg & Stock Location:

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Reject
Number

Insp.
Stamp

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

PPP 99430

0.00

13/4/10

MF

1349

Picklist Print

July 19-12 11:30:17 AM

Work Order ID: 87938

Parent Item: D3245-043

Parent Item Name: Door Assembly

87938
D3245-043

Start Date: 19/07/2012

Start Qty: 10.00

Required Date: 02/08/2012

Required Qty: 10.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

~~2351-20-012-C3Y~~

Purchased

STUD

127H-35

Purchased

~~*127H-35*~~

HALF GROMMET

D3245-3

~~*D3245-3*~~

Door

Manufactured

No

110

Each

25.0000

1

**

Location	Loc Qty	Loc Code
----------	---------	----------

ST400	107	
-------	-----	--

122149

107

107

100	Each	164.0000
-----	------	----------

8

80

**

Location	Loc Qty	Loc Code
----------	---------	----------

GA	16	
----	----	--

119545

16

ST378	140	
-------	-----	--

121827

140

ST398	8	
-------	---	--

117203

8

118261	5	
--------	---	--

118261

5

110	Each	25.0000
-----	------	---------

1

**

Location	Loc Qty	Loc Code
----------	---------	----------

GA	25	
----	----	--

77821

25

85956	5	
-------	---	--

86106

5

10		
----	--	--

10

10

**

Page 1

Picklist Print

July-19-12 11:30:17 AM

Page 2

Work Order ID: 87938

Parent Item: D3245-043

Parent Item Name: Door Assembly

87938
D3245-043

Start Date: 19/07/2012

Required Date: 02/08/2012

Start Qty: 10.00

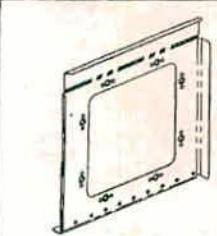
Required Qty: 10.00

D3245-7
D3245-7
Gasket

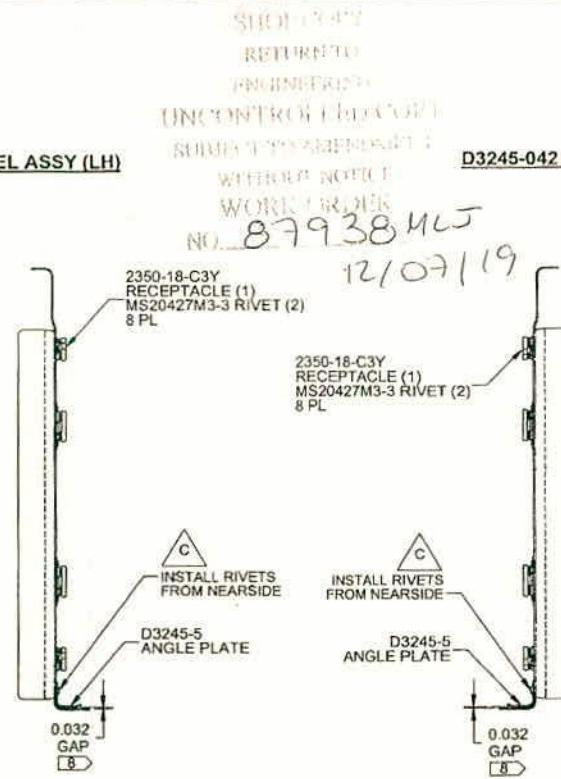
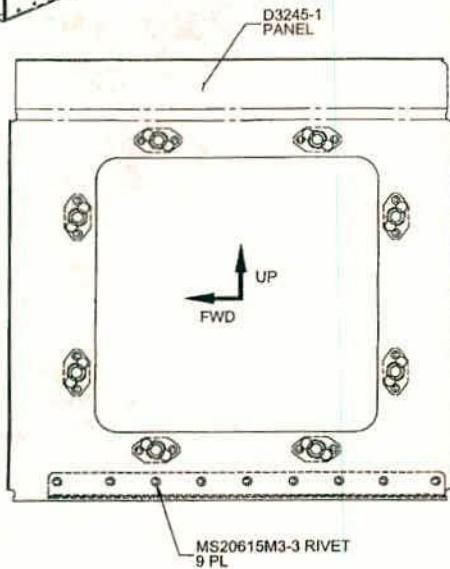
Manufactured No 110 Each 34.0000 1 10 **

EBS/03/20

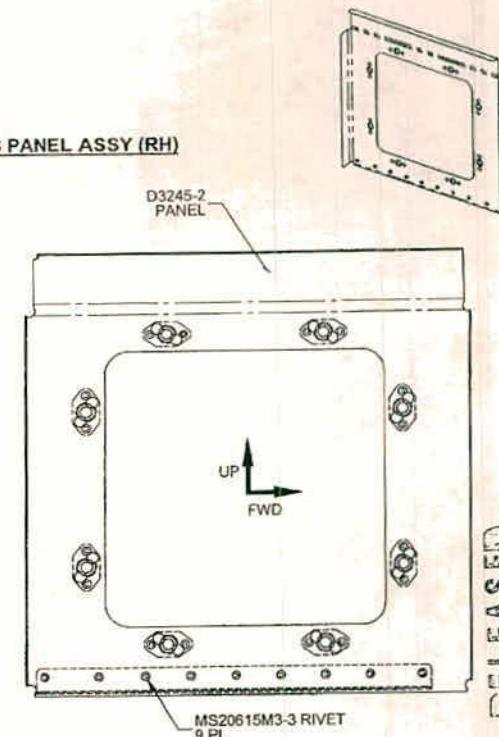
Location	Loc Qty	Loc Code
GA	14	
83197	2	
85957	12	4
ST232A	20	
86107	20	5



D3245-041 ACCESS PANEL ASSY (LH)



D3245-042 ACCESS PANEL ASSY (RH)



C	ADDED NOTE 8. SHEET 1: CHANGED STUD ORIENTATION (B4-1, B5-1) CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D5-1). HOLE SIZE WAS 0.219, 6 PLACES (D5-2). REMOVED (2) 0.204 HOLES FROM D3245-1-1P. REMOVE MS21090-13K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING.	RP	12.04.11
B		MB	07.10.02
A	NEW ISSUE		
REV.	RF	BY	DATE
	DESIGN	RF	DART AEROSPACE LTD
	DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
	CHECKED	A.P.	DRAWING NO.
	MFG. APPR.	<i>[Signature]</i>	D3245
	APPROVED	<i>[Signature]</i>	SHEET 1 OF 7
	DE APPR.	<i>[Signature]</i>	TITLE
	DATE	12.04.11	SCALE
			NTS
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- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
 7) WEIGHT: 0.83 lbs
 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSY (LH)
		D3245-042	ACCESS PANEL ASSY (RH)
1	1	D3245-1	PANEL
1	1	D3245-2	PANEL
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

07038

8

7

6

5

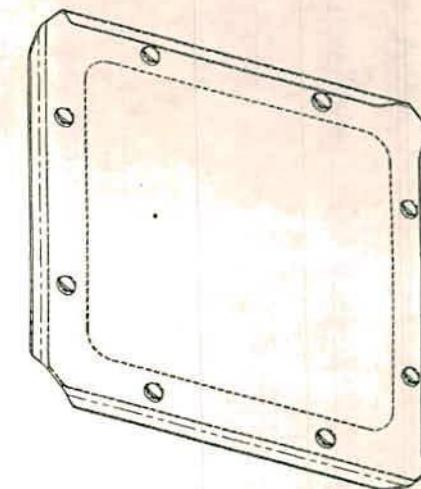
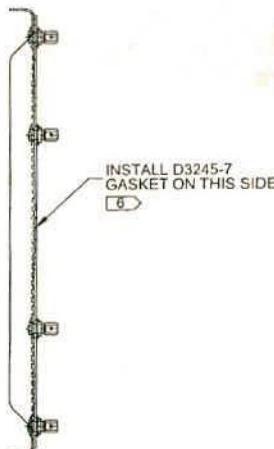
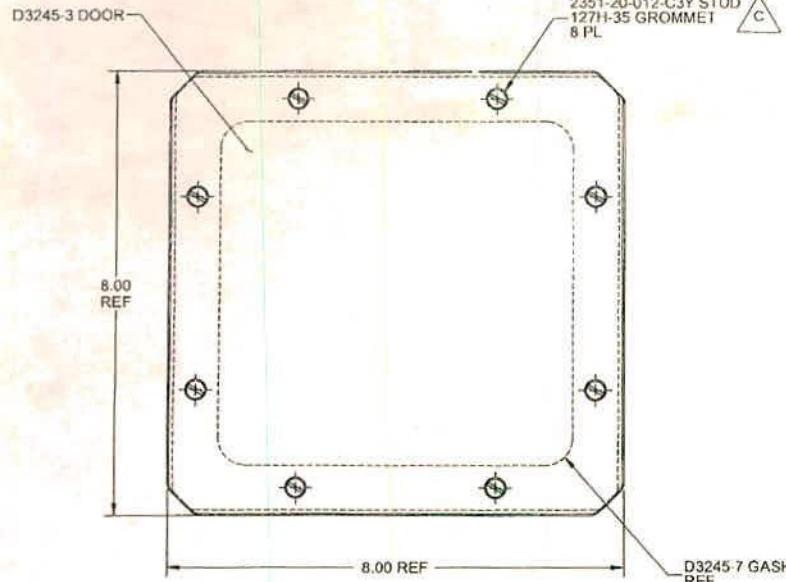
4

3

2

D

D



D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

8

7

6

5

4

3

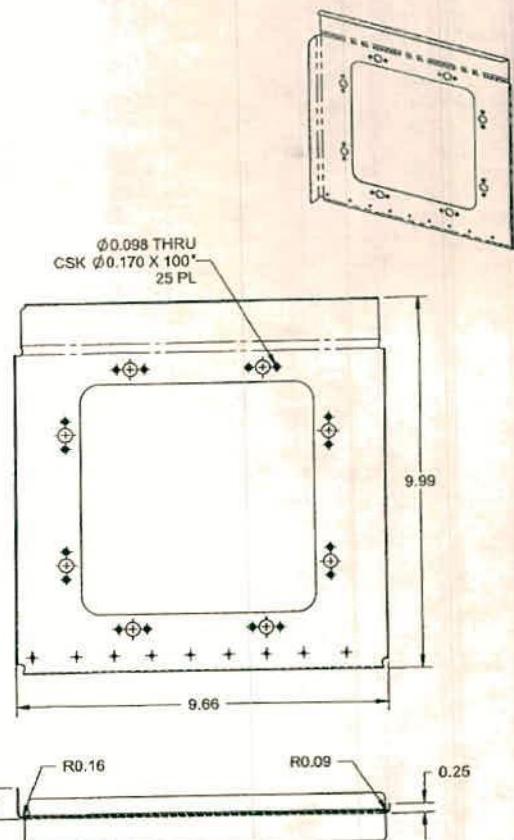
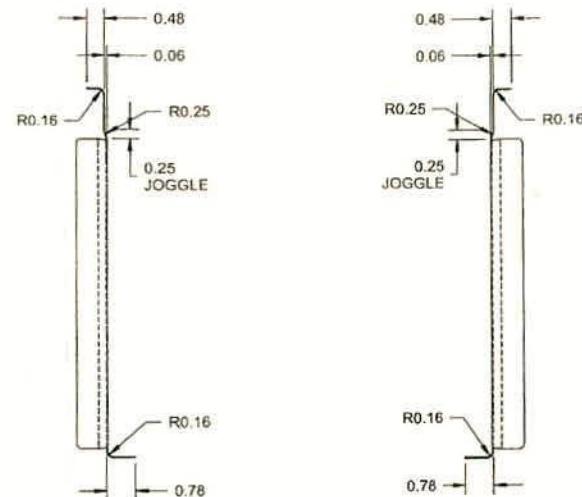
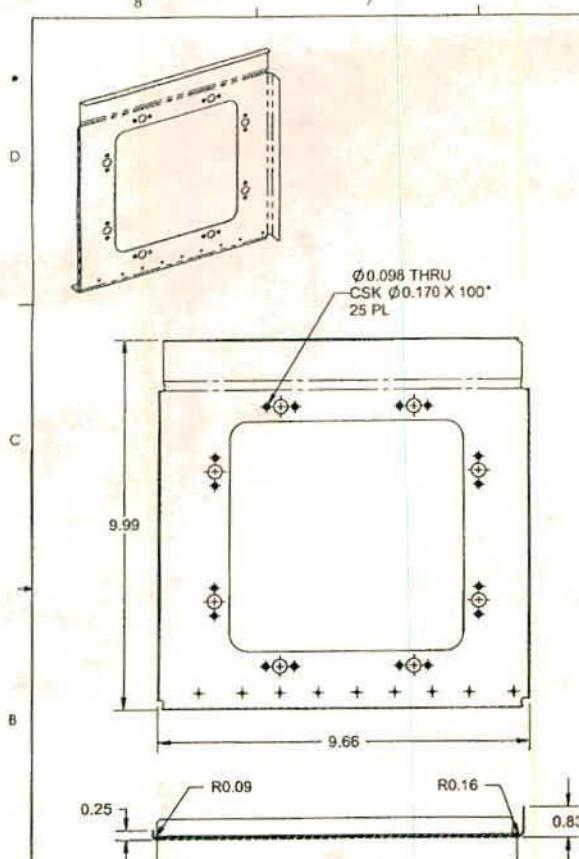
2

1

LEASE
2012-05-07
JAD

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CHECKED	AP	REV. C
		DRAWING NO.
		D3245
		SHEET 2 OF 7
		TITLE
		SCALE
		NTS
DE APPR.	SH	ACCESS PANEL ASSY
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR DART AEROSPACE LTD PURPOSES ONLY. IT IS NOT TO BE COPIED OR USED FOR ANY OTHER PURPOSE OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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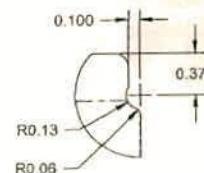
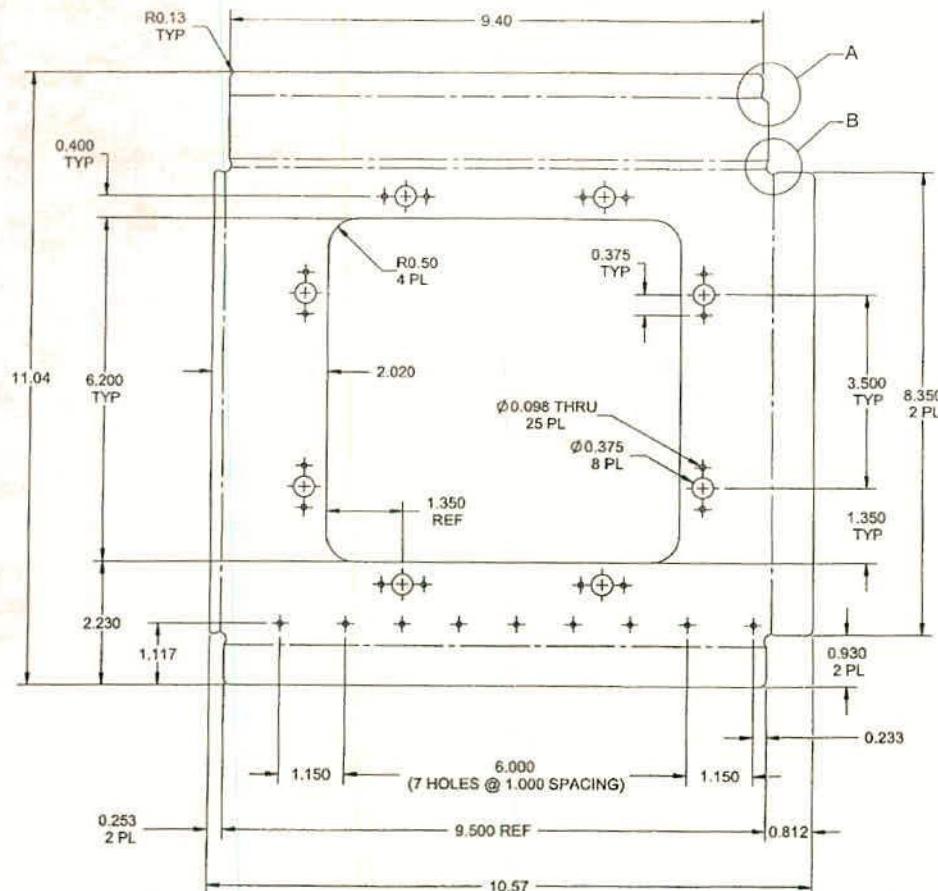
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2012-05-07

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DE APPR.	S.P.	SCALE
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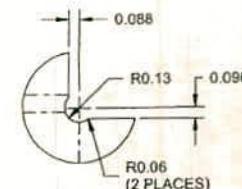
ACCESS PANEL ASSY

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87938



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
TYP, 4 PL
SCALE 1:1

RELEASE
2012-05-07
NP

NOTES:

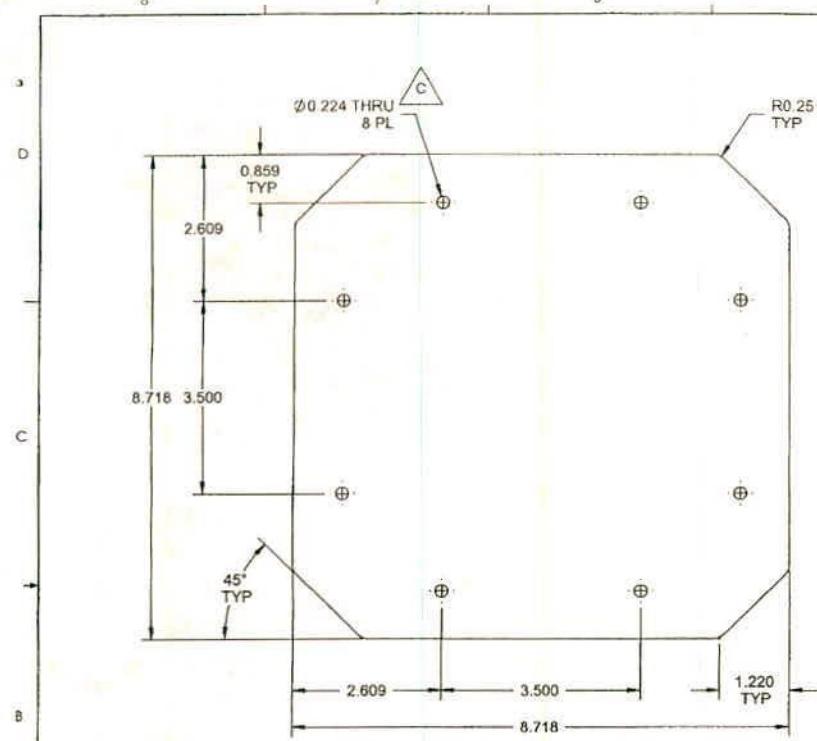
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

D3245-1F PANEL FLAT PATTERN

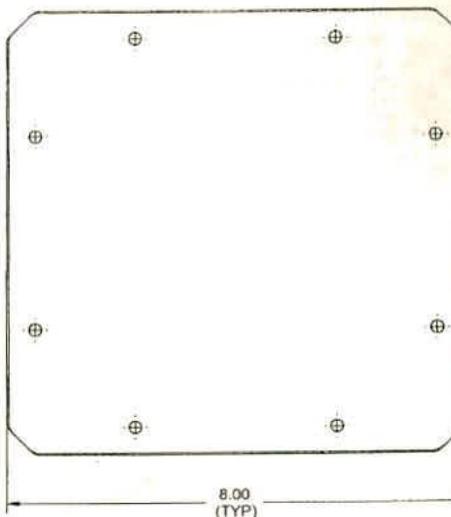
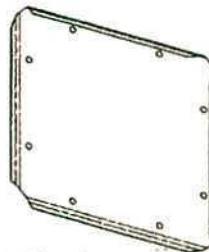
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MFG. APPR.		DRAWING NO.	D3245
APPROVED		SHEET 4 OF 7	
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D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR
(MADE FROM D3245-3F)

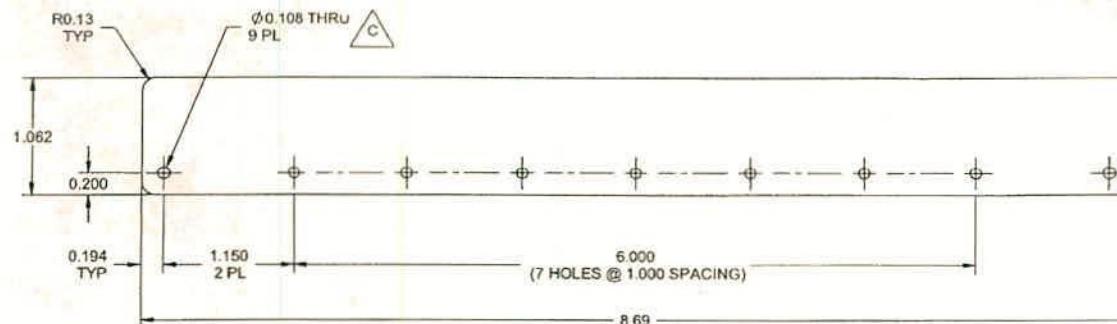
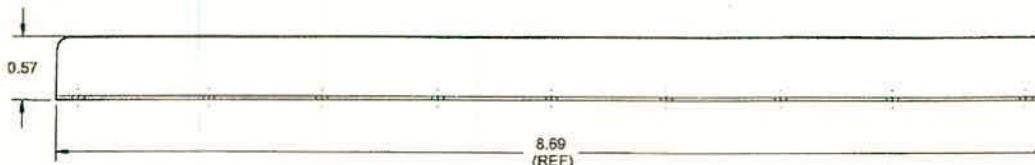
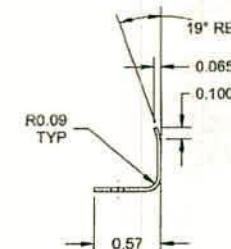
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs

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RELEI.
RI 2012-05-07
NP

87938

D3245-5 FLAT PATTERND3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)REL. 1.3E
R 2012-07-07
AP

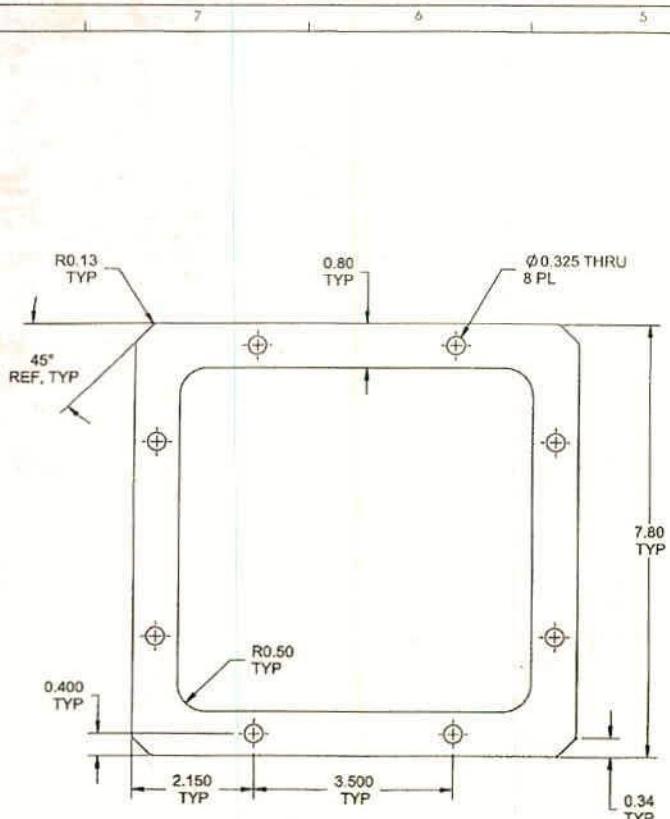
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-6059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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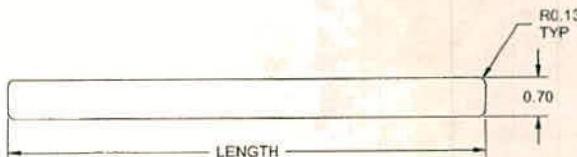
87950



D3245-7 GASKET

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

2012-03-07
MP

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MFG. APPR.	SD	REV. C
APPROVED	ND	D3245
DE APPR.	SD	SHEET 7 OF 7
DATE	12.04.11	TITLE
		ACCESS PANEL ASSY
		NTS

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